

Work Order ID 79189***79189***

Page 1

Monday, January 23, 2012 11:25:43 AM

Item ID: D4108-049

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Door Fitting Assembly

Start Date: 1/23/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/23/2012 Req'd Qty: 1.00

1

Customer:

Reference: ALODINE

*Rework*Approvals: Process Plan: *MF*Date: *12-01-23* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4108

B

150

0.00

150

Small Fab

Memo

0.00

Small Fab

PULL FROM STOCK D4108-049 AND DISSASSEMBLE

KEEP HARDWARE

BRING PART D4108-9 TO ALODINE

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

*12/01/23**1 BL 12-1-23*

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Reference: ALODINE

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

IXP M-P 12/03/23

180

0.00

180

Small Fab

Memo

0.00

Small Fab

RE-ASSEMBLE D4108-049 PER DRAWING

12/01/24
12/11/23

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

8 12/6/24

(4)

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Customer:

Reference: ALODINE

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: _____

0.00

200

Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

201

QC21- Final Inspection - Work Order Release

0.00

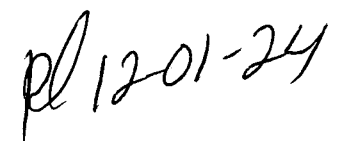
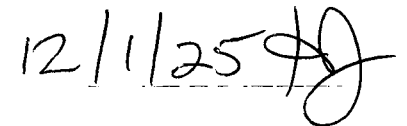
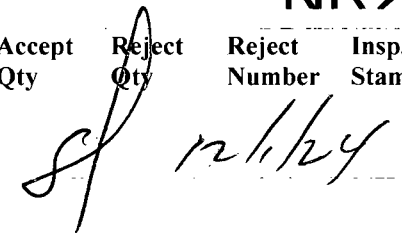
201

QC

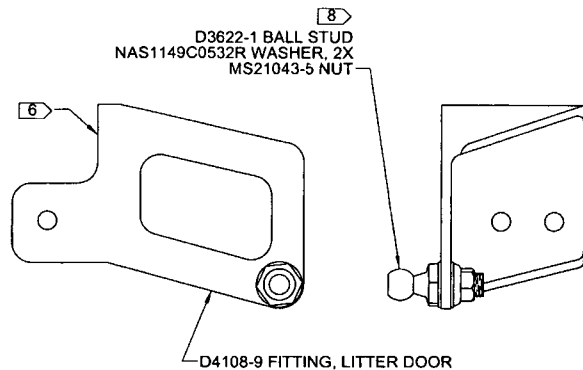
Memo

0.00

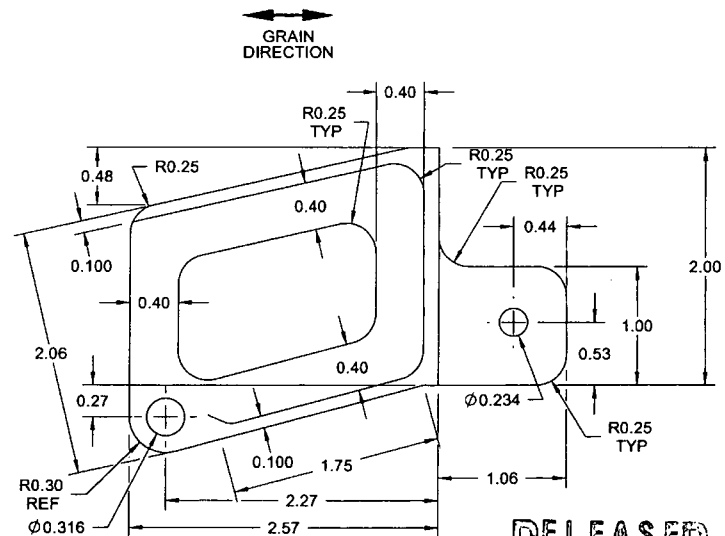
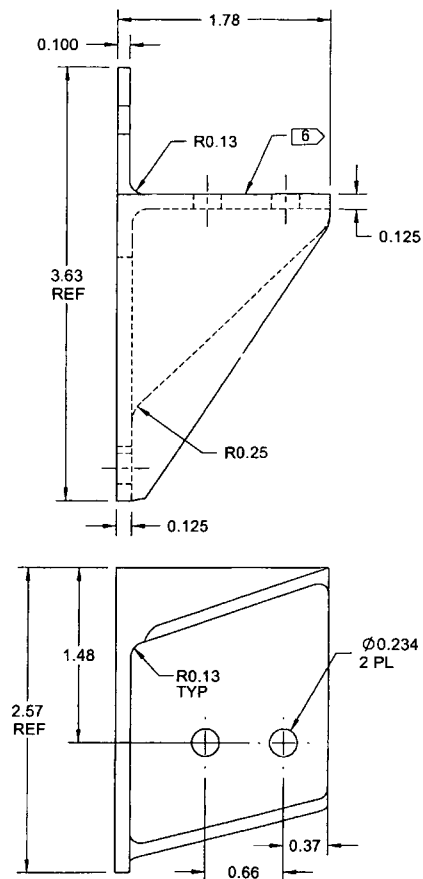
Quality Control



Qty -049	Part Number	Description
1	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



D4108-049 LITTER DOOR FITTING ASSEMBLY



D4108-9 FITTING, LITTER DOOR

- NOTES:**
- 1) MATERIAL -9: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
 - 7) WEIGHT -049: 0.19 lbs
 - 8) TORQUE TO 15 INCH POUND.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
DATE	10.11.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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RELEASED
2010-11-30